Work Order ID 124550

September-15-14 7:27:23 AM

124550

Item ID: D3272-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Step **Stop** *NS2*

Start Date: 9/15/14 **Start Qty:** 10.00 *10*

Required Date: 9/19/14 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3272	Rev B								
100		0.00							
100	Large Fab								
Large Fab	**Memo**	0.00							
Large Fab	***SQUARE ONE END BEFORE CUTTING OTHER END*** 1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. 3-Deburr					10	DMC		14-09-15
							QC		14-9-15
110	QC6- Inspect dimensions to drawing	0.00				10	SEP 15 2014		DAS 24 9-89
110									
QC	**Memo**	0.00							
Quality Control									

Work Order ID 124550

September-15-14 7:27:23 AM

124550

Item ID: D3272-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Step

Start Date: 9/15/14 **Start Qty:** 10.00 *10*

Required Date: 9/19/14 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: WA3	0.00				10	SEP 15 2014		DAS 24 9-89
120									
Packaging	**Memo**	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00					14/9/16		
130									
QC	**Memo**	0.00							
Quality Control									

9-16

Picklist Print

September-15-14 7:27:23 AM

Work Order ID: 124550

124550

Parent Item: D3272-1

D3272-1

Parent Item Name: Step

Start Date: 9/15/14 **Required Date:** 9/19/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	114.0000	1	10			
D2622-120C									**				
Step Extrusion													

DMC 14-09-15

Location	Loc Qty	Loc Code	
HALL	110		
109575	32		
119621	78		10 x
WA003	4		
101765	1		
115141	3		

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3272	SHEET 1 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	NTS

A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

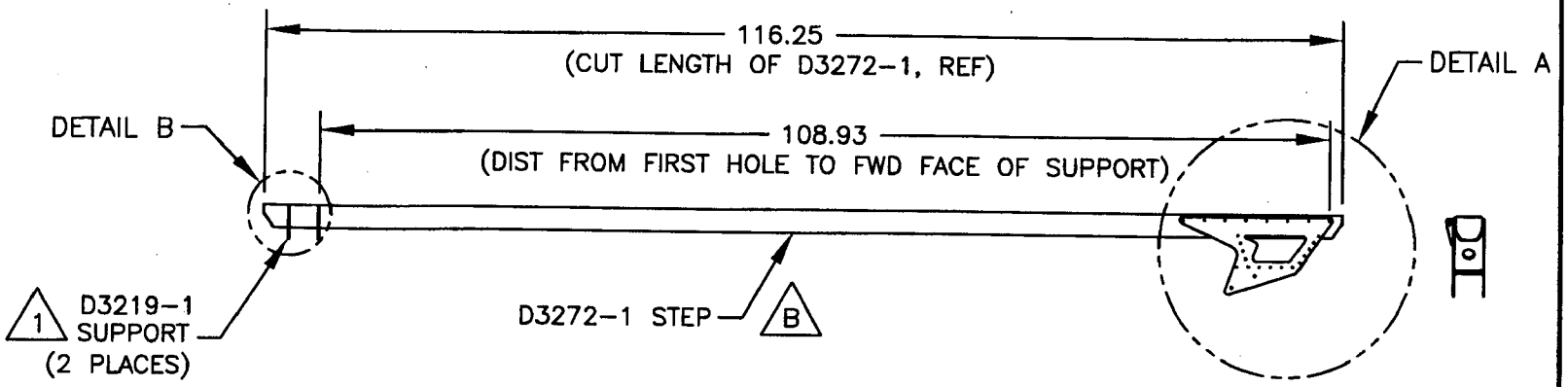
RELEASED
07 06 04

	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
	X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
		X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
	1	1	D3065-041	LEG ASSEMBLY
	2	2	D3066-1	SPACER
	2	2	D3067-1	END PLATE
	2	2	D3219-1	SUPPORT
B	1	1	D3272-1	STEP
	16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

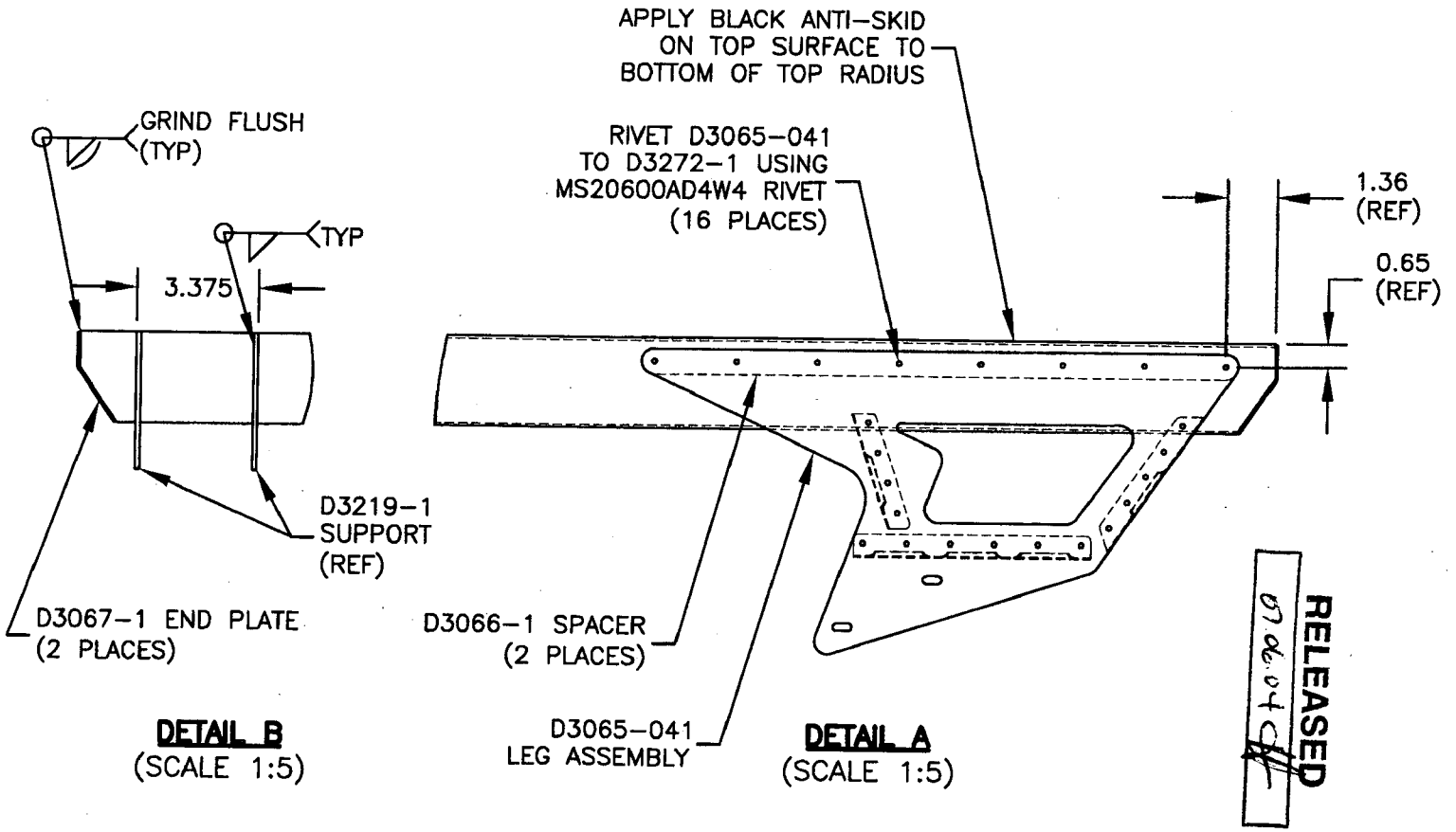
1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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D3272-041 STEP ASSEMBLY (LH, SHOWN)

D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

RELEASED
07.06.04

DART

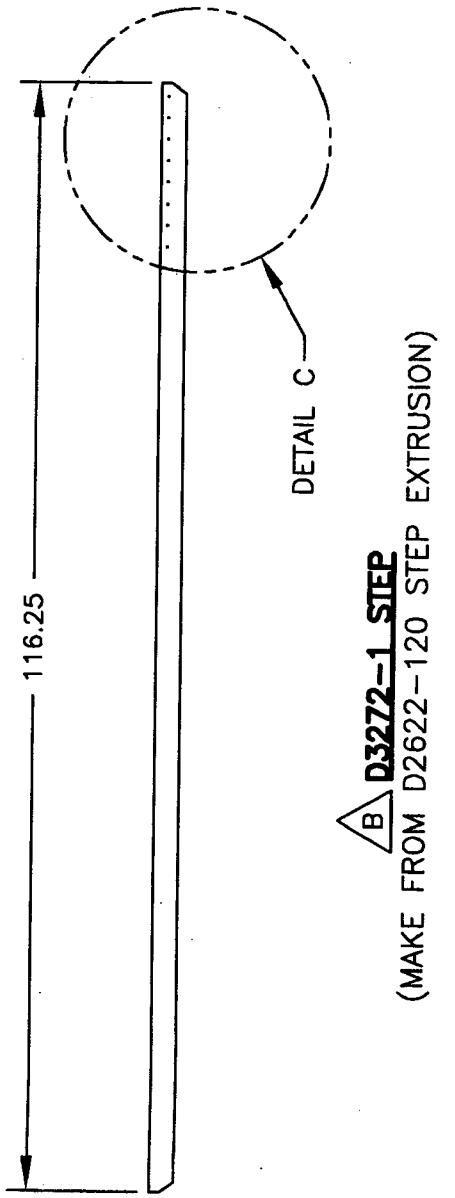
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DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3 SCALE 1:20

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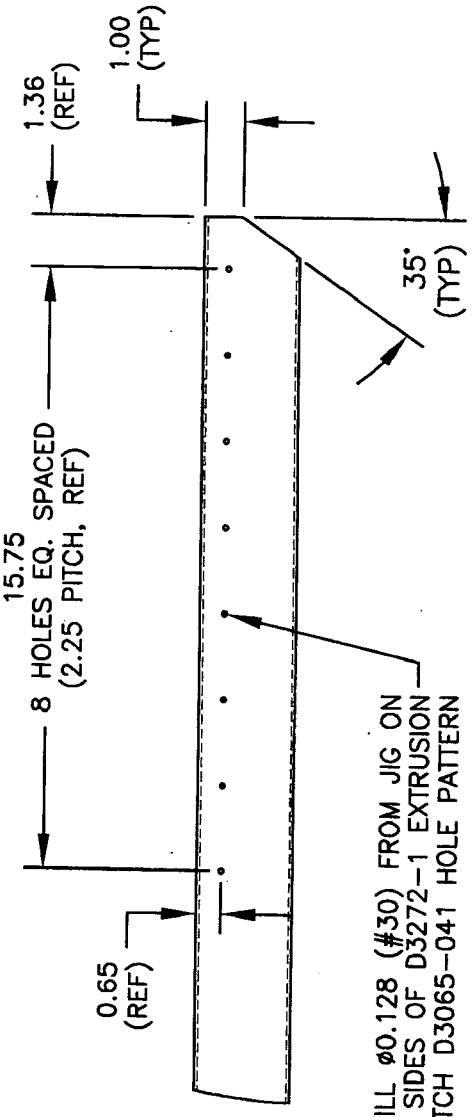
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DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED
07.06.04



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

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